

Work Order ID 129775

February-23-15 10:21:17 AM

129775

Page 1

Item ID: D206-817-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Screw-In Windshield Modification

Start Date: 3/05/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/16/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 15-02-24

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	DAS 36 9-89	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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DSI9659	A
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DSI9687	A
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IIN-D206-817	D
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100	Document Control	0.00
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100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile & type labels per PPP D206-817-011 CHG006

MLJ 1507-17-2

DAS

38

9-89

15-10-01

110	Pick Kit	0.00
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110

Packaging

Packaging

Memo

0.00

② JA

JUL 23 2015

27

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID 129775

February-23-15 10:21:17 AM

129775

Page 2

Item ID: D206-817-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Screw-In Windshield Modification

Stop

NS2

Start Date: 3/05/15 Start Qty: 2.00

2

Cust Item ID:

Required Date: 3/16/15 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00				2			DAS 38 9-89
Quality Control									15-10-01
130		0.00							
130	Packaging								DAS 02 9-89
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D206-817-011 Location: <u>FG 033</u>								OCT 06 2015
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									MLJ OCT 6 6 2015

MLJ OCT 6 6 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 1

Work Order ID: 129775

129775

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 12.02.14 NEW ISSUE DD VERF: IPP REV:B
12.05.09 AS PER IIN REV.C DD VERF:EC IPP REV:C 12.06.12
ECN 12-602 DD VERF:EC IPP REV:D 13.04.23 as per IIN
dwg rev.D DD verf:JLM IPP REV:E 13.06.26 as per
CHG004/DSI9659 DD VERF:JFS IPP REV:F 14.03.24 AS PER DSI 9687
DD VERF:JLM IPP REV:G 15.01.06 now @ chg006/ecn14-547 DD
verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-1 *D4541-1* Bracket		Manufactured	No			110	Each	22.0000	1	2			
									**	JA			DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST626				22					
				118995				2					
				26489				8		2			
				127095				12					
D4541-2 *D4541-2* Bracket		Manufactured	No			110	Each	21.0000	1	2			
									**	JA			DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST626				21					
				125732				4					
				12649				5		2			
				127096				12					
D4542-1 *D4542-1* Retainer, Inner, LH		Manufactured	No			110	Each	8.0000	1	2			
									**	JA		JUL 23 2015	DAS 27 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST628				8					
				116077				3					
				122802				5					
				0129 997						2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Doc/Data									
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Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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Picklist Print

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Page 3

Work Order ID: 129775

129775

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

D4541-6	DAS	Manufactured	No	110	Each	18.0000	1	2		
D4541-6	38									
Bracket,RH	9-89									
							**	JA-		DAS 27 9-89

Location	Loc Qty	Loc Code
st631	18	
115293	3	
123645	5	
<u>127100</u>	10	

D4541-7	DAS	Manufactured	No	110	Each	15.0000	1	2		
D4541-7	38									
Bracket	9-89									
							**	JA		DAS 27 9-89

Location	Loc Qty	Loc Code
ST635	15	
116104	2	
122362	1	
<u>127103</u>	12	

D4541-8	DAS	Manufactured	No	110	Each	20.0000	1	2		
D4541-8	38									
Bracket	9-89									
							**	JA		DAS 27 9-89

Location	Loc Qty	Loc Code
ST635	20	
115956	1	
123652	7	
<u>127102</u>	12	

D4542-3	DAS	Manufactured	No	110	Each	21.0000	2	4		
D4542-3	38									
Retainer, Inner	9-89									
							**	JA	JUL 23 2015	DAS 27 9-89

Location	Loc Qty	Loc Code
ST629	21	
121013	9	
<u>127103</u>	12	

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Shop Packet Print

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WORK ORDER NON-CONFORMANCE / UPDATE

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Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 129775

129775

Parent Item: D206-817-011

D206-817-011

Parent Item Name: Screw-In Windshield Modification

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

D4542-5	DAS 38 9-89	Manufactured	No	110	Each	14.0000	2	4		68-6 27 9-89
D4542-5							**	J.A.		
Retainer, Inner										

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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st631	14	
126360	4	
128254	10	

D4542-7	DAS 38 9-89	Manufactured	No	110	Each	19.0000	2	4	4	68-6 27 9-89
D4542-7							**	J.A.		
Retainer, Inner										

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st631	19	
116675	7	
127104	12	

D4543-1	DAS 38 9-89	Manufactured	No	110	Each	10.0000	1	2		68-6 27 9-89
D4543-1							**	J.A.		
Retainer, LH Outer (Lower)										

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

st630	10	
126144	2	
126486	8	

D4543-2	DAS 38 9-89	Manufactured	No	110	Each	5.0000	1	2		68-6 27 9-89
D4543-2							**	J.A.	JUL 23 2015	
Retainer, Outer, RH										

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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st630	5	
125603	5	
B128255		

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Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐															
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐															
Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Work Order ID: 129775

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

129775

D206-817-011

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

D4543-3

D4543-3

Retainer, Outer, LH

DAS
38
9-89

Manufactured No

110 Each 6.0000 1 2

**

JA

DAS

27

9-89

Location

Loc Qty

Loc Code

ST632

6

122334

1

126485

5

B127105

110 Each

9.0000

1 2 2

**

JA

DAS

27

9-89

Location

Loc Qty

Loc Code

ST632

9

122250

2

126484

7

2

D4543-5

D4543-5

Retainer, Outer, LH

DAS
38
9-89

Manufactured No

110 Each 8.0000 1 2

**

JA

DAS

27

9-89

Location

Loc Qty

Loc Code

ST634

8

122372

1

126483

7

1

D4543-6

D4543-6

Retainer, Outer, RH

DAS
38
9-89

Manufactured No

110 Each 7.0000 1 2

**

JA

JUL 23 2015

DAS

27

9-89

Location

Loc Qty

Loc Code

ST634

7

108205

1

115993

1

123666

5

B127108

2

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved *									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Work Order ID: 129775

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

129775

D206-817-011

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

MS20426AD3-4

Purchased

No

110

Each

2,106.000

190

380

MS20426AD3-4

DAS
38
9-89

RIVET

**

JA

DAS

27

9-89

Location

Loc Qty

Loc Code

CA

12

125578

12

GA

1720

m127432

1720

380

MF4

36

125578

36

ST313

338

125578

338

MS21059L08

Purchased

No

110

Each

504.0000

43

86

MS21059L08

DAS
38
9-89

Nut

**

JA

JUL 23 2015

DAS

27

9-89

Location

Loc Qty

Loc Code

MF4

74

125654

74

ST302

430

m129934

110

m131317

120

m131624

200

86

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 129775

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

129775

D206-817-011

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

MS21059L3K

DAS Purchased
38
9-89

No

110

Each

1,146.000

93

186

MS21059L3K

Nutplate

**

JA

27
9-89

Location

Loc Qty

Loc Code

GA

205

m127635

205

ST273A

700

m131618

700

ST303

241

m129913

241

186

MS21061L08

Purchased

No

110

Each

86.0000

10

20

MS21061L08

Nutplate

DAS
38
9-89

**

JA

27
9-89

Location

Loc Qty

Loc Code

ST302

86

m128635

11

m130799

25

m131187

50

m131697

110

Each

137.0000

1

2

MS21075L08

Purchased

No

MS21075L08

ANCHOR NUT

DAS
38
9-89

**

JA

27
9-89

Location

Loc Qty

Loc Code

ST300

137

M128635

137

M131420

110

Each

1,193.000

42

84

MS27039-08-10

Purchased

No

MS27039-08-10

Screw

38
9-89

**

JA

JUL 23 2015

27
9-89

Location

Loc Qty

Loc Code

ST281

1193

m128799

1193

84

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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Work Order ID: 129775

Parent Item: D206-817-011

Parent Item Name: Screw-In Windshield Modification

129775

D206-817-011

Start Date: 3/05/15

Required Date: 3/16/15

Start Qty: 2.00

Required Qty: 2.00

NAS1149DN832J

Purchased

No

110

Each

1,058.000

42

84

NAS1149DN832.J

Washer

DAS
38
9-89

**

JA

27
9-89

Location

Loc Qty

Loc Code

CA

84

M129499

84

MF4

185

M129541

185

ST270

789

124555

15

M128429

74

M131317

600

M131624

100

M131697

110

Each

70.0000

84

2

4

MS21061L3K

Purchased

No

MS21061L3K

NUT PLATE

DAS
38
9-89

**

JA

JUL 23 2015

27
9-89

Location

Loc Qty

Loc Code

GA

56

125268

6

m131467

50

ST302

14

123603

14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
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		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 13.06.20
CERT. NO.: SH12-3
ISSUE NO.: 1

A	NEW ISSUE	OS	13.06.20
REV.	DESCRIPTION	BY	DATE
DESIGN	OS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OS		
CHECKED	140	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	OS	TITLE	SCALE
DE APPR.	17	SEALANT TAPE	NTS
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150-25
130-13

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2

REF. TCCA STC SH12-3
REF. FAA STC SR03091NY
REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
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DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9687	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RETAINER UPGRADE	NTS
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3.0 INSTALLATION

IF INSTALLING A D206-817-011 KIT AT CHG 005 OR LATER, STEP 3.3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV D IS MODIFIED IS FOLLOWS:

- 3.3 Install Dart inner retainers. It is acceptable to hand form retainers as required to allow fit. Retainers should be located so that they are approximately flush with the aircraft skin. Locate retainers and transfer drill $\varnothing 0.128$ " from aircraft frame. Locate as follows, using Figure 3-2 as reference:

- Locate D4541-1/-2 Brackets along the bottom window frame flush against the door pillars. The Bracket should be oriented with the hole pattern for the MS21061L3K nutplate (the non-symmetric nutplate, ref) near the door post. See Figure 3-3 for reference.
- Locate D4541-3/-4 Brackets on the door pillars, above the -1/2 Brackets. See Figure 3-3.
- Locate D4541-5/-6 Brackets above the -3/-4 retainers. See Figure 3-4.
- Locate D4541-7/-8 Brackets along the top edge, with one side aligned with the center column. See Figure 3-4.
- Relocate the 206-031-112-039 (or equiv.) clip removed at step 3.2(g) per Figure 3-3.

Install brackets wet with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 sealant between retainers and a/c frame. Fasten D4541-1/-2 Lower Inner Brackets with CR3214-4 (or NAS9301B or M7885/2) rivets and NAS1149DN432J (or 140-001-1 or AN960JD4 or equiv.) washers. Fasten D4541-X Brackets with MS20600AD4 rivets. Reinstall clip (206-031-112-039 or equiv.) with CR3213-4 rivets. See Figure 3-3 for reference.

*Note: Due to variations in airframes the D4541-X Brackets have been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

- 3.4 Locate D4542-X Retainers onto the D4541-X Brackets as follows, see Figures 3-3 & 3-4 for reference:

- Locate D4542-1 Retainers onto the D4541-1/-2 Brackets
- Locate D4542-3 Retainers onto the D4541-3/-4 Brackets
- Locate D4542-5 Retainers onto the D4541-5/-6 Brackets
- Locate D4542-7 Retainers onto the D4541-7/-8 Brackets

Hand form D4541-X Brackets and/or D4542-X as required to fit profile of windshield. Locate and transfer drill rivet holes to D4542-X Retainers and open to $\varnothing 0.098$. Locate and transfer drill screw holes and open to $\varnothing 0.250$ ". Dimple the $\varnothing 0.098$ holes $\varnothing 0.180 \times 100^\circ$ and install MS21059L3K nutplates with MS20426AD3-4 rivets.

*Note: Due to variations in airframes the D4542-5 Retainer has been designed with extra material for ease of installation and to maintain a good edge distance. Excess material may be trimmed. Touch-up trimmed parts with alodine 1200/1201 per MIL-C-5541.

FIGURES 3-2 & 3-3 OF INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D ARE MODIFIED AS SHOWN ON SHEETS 3 AND 4 OF THIS SERVICE INSTRUCTION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED 	
BY:	D. SHEPHERD (DE # 02)
DATE:	14.03.18
CERT. NO.:	SH12-3
ISSUE NO.:	1

DESIGN	AJS	DART AEROSPACE LTD	
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MFG. APPR.	N/A	DSI 9687	SHEET 2 OF 4
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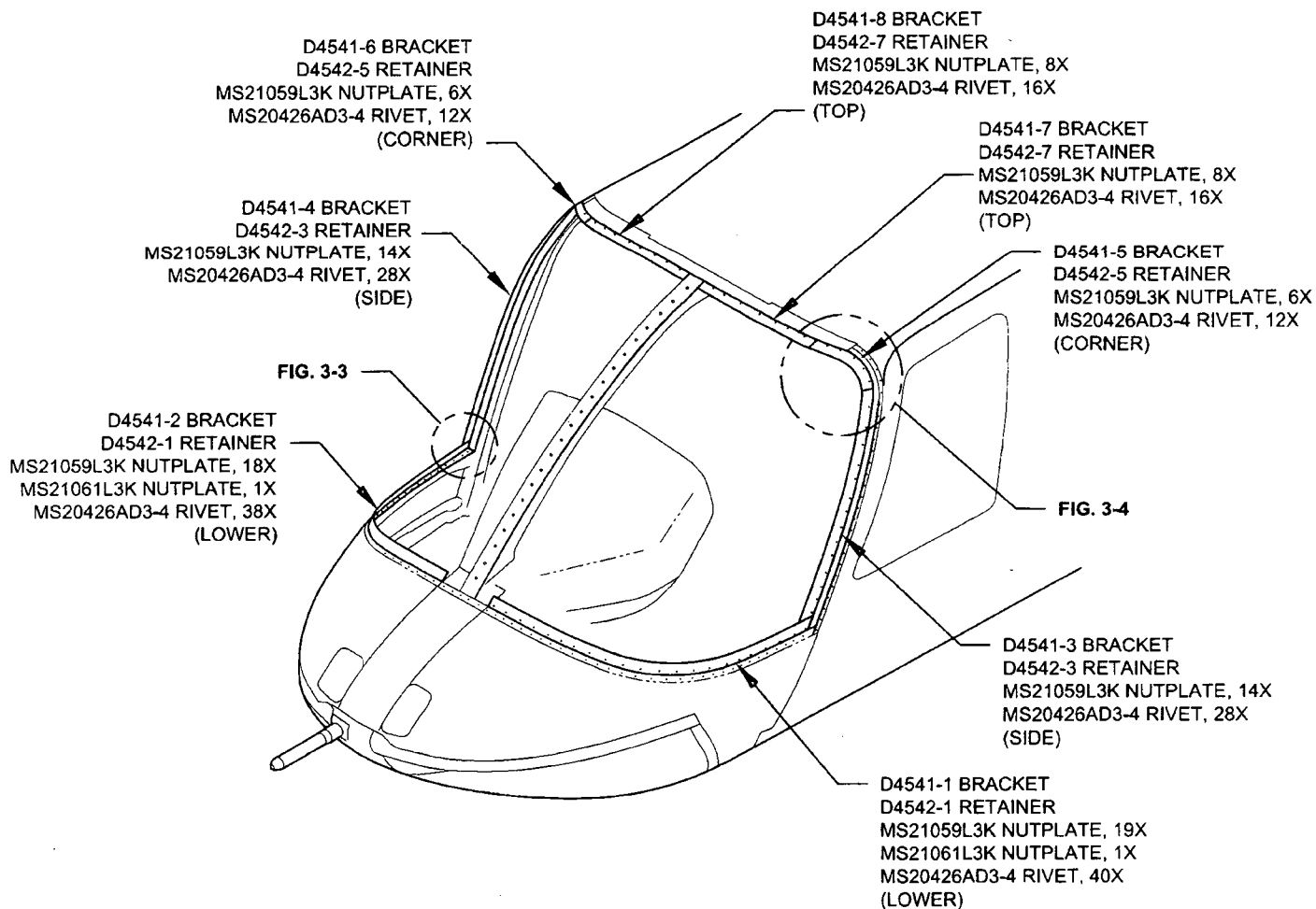


FIGURE 3-2
(REF IIN-D206-817 REV D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.18
CERT. NO.: SH12-3
ISSUE NO.: 1

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MFG. APPR.	N/A	DSI 9687	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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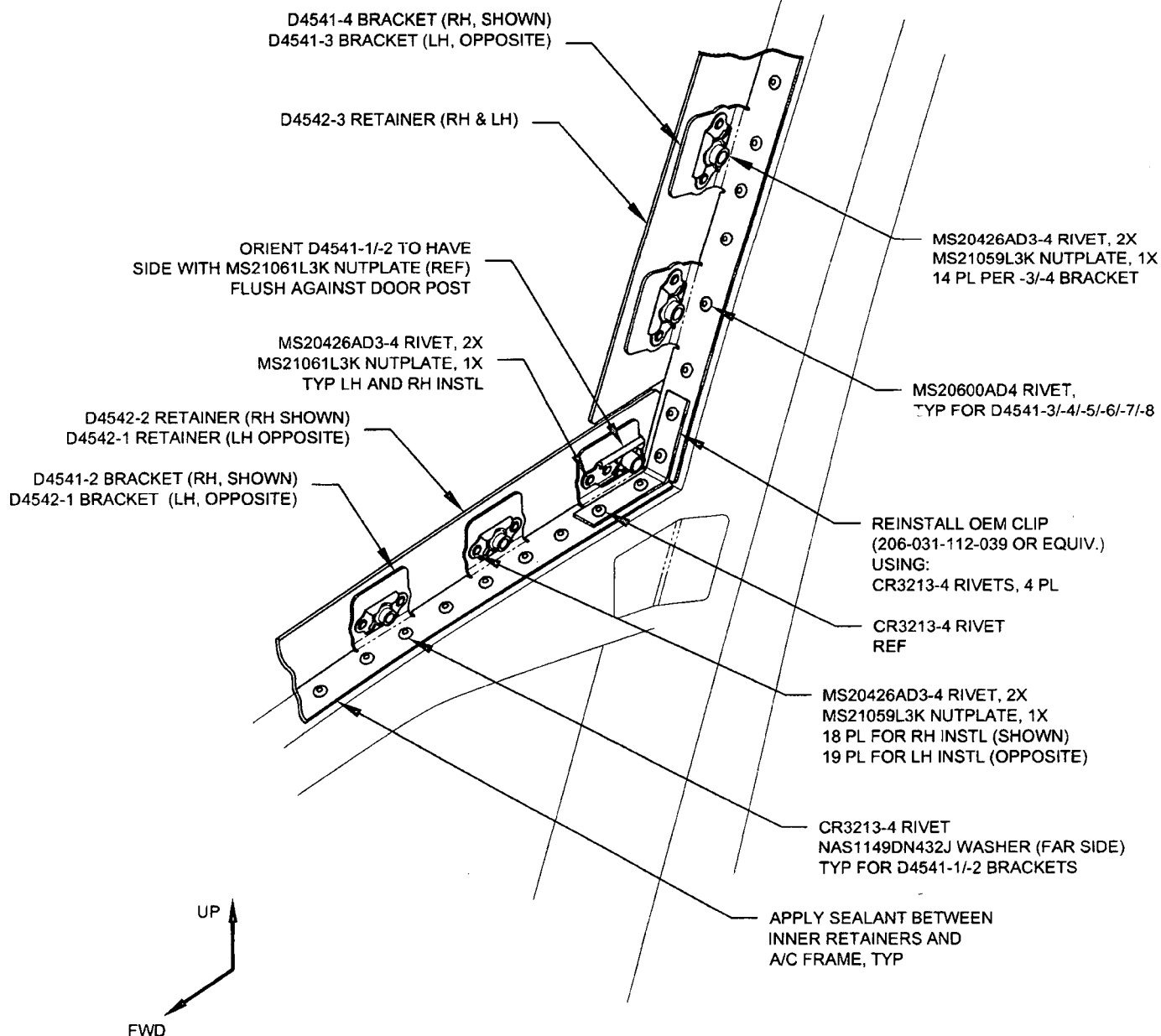


FIGURE 3-3
(REF IIN-D206-817 REV D)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.03.18
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MFG. APPR.	N/A	DSI 9687	SHEET 4 OF 4
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Work Order ID 129775

February-23-15 10:21:17 AM

129775

Page 1

Item ID: D206-817-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Screw-In Windshield Modification
 Start Date: 3/05/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 3/16/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1502-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI9659	A
DSI9687	A
IIN-D206-817	D

100 Document Control 0.00
100 DOCUMENT CONTROL
 DC Memo 0.00
 Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D206-817-011 CHG006

MLJ JUL 17 2015

(Handwritten signature)

110 Pick Kit 0.00
110
 Packaging Memo 0.00
 Packaging



RELEASED
7/63/26 SJ

PPP

Part Number	D206-817-011
Description	Screw-In Windshield, LH/RH

Box Part Number	Telescopic	Dimension	24 x 8 x 57
Other Packaging	Uline S14259	Dimension	50 x 9 x 25
Logo Decals			

Packaging Instructions and Decal Placement

D206-817-011

Place bubble wrap in the bottom of the box. Wrap the kit in bubble wrap, apply label and place in box. Put more bubble wrap in box to prevent movement. Close box. Apply Dart label around box. Apply label D2729-3 as per instructions in QSI 014.

D2729-4

N/A

D2729-3



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200

SCREW-IN WINDSHIELD, LH/RH

P/N: D206-817-011

CHG006

B/N: BXXXXXX

Revision: G

Date: 15.01.06

15/01.06

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV.2
OR LATER APPROVED REVISION

REF. TCCA STC: SH12-3
REF. FAA STC: SR03091NY
REF. EASA STC: 10039042

1.0 PURPOSE

AT CHG 004 AND SUBSEQUENT, THE D206-817-011 SCREW-IN WINDSHIELD MODIFICATION KIT WILL NOW INCLUDE 2x D4595-150-13 SEALANT TAPE (13' LONG) IN LIEU OF 1x D4595-150-25 SEALANT TAPE (25' LONG) IN ORDER TO AVOID THE EXPIRATION OF UNUSED TAPE SHOULD ONLY ONE REPLACEMENT WINDSHIELD BE NECESSARY.

2.0 PARTS LIST

WAS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4595-150-25	SEALANT TAPE (25' LONG)

IS:

QTY -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
2	D4595-150-13	SEALANT TAPE (13' LONG)

3.0 INSTALLATION

INSTALL THE D4595-150-13 SEALANT TAPE IN THE SAME WAY AS THE D4595-150-25 SEALANT TAPE PER IIN-D206-817 REV. D OR LATER APPROVED REVISION.

4.0 WEIGHT AND BALANCE

THIS CHANGE HAS NO EFFECT ON THE WEIGHT AND BALANCE.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 13.06.20
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DRAWN	<u>OS</u>		
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MFG. APPR.	N/A	DSI 9659	SHEET 1 OF 1
APPROVED	<u>OS</u>	TITLE	SCALE
DE APPR.	<u>11</u>	SEALANT TAPE	NTS
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-817 REV. D
& INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-817 REV. 2
REF. TCCA STC SH12-3
REF. FAA STC SR03091NY
REF. EASA STC 10039042

1.0 PURPOSE

THE PURPOSE OF THIS DART SERVICE INSTRUCTION (DSI) IS TO FACILITATE INSTALLATION OF THE RETAINERS ON THE LOWER PORTION OF THE WINDSHIELD, FOR D206-817-011 KITS AT CHG 005 OR LATER, BY REPLACING THE RIGID D4545-041/-042 RETAINER ASSEMBLIES WITH SEPARATE BRACKETS AND RETAINERS THAT ARE ASSEMBLED BY THE INSTALLER AND ALLOW FOR EASIER ADJUSTMENT.

2.0 PARTS LIST

(IS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-1	BRACKET
1	D4541-2	BRACKET
1	D4542-1	RETAINER
1	D4542-2	RETAINER
190	MS20426AD3-4	RIVET
43	MS21059L08	NUTPLATE
93	MS21059L3K	NUTPLATE
2	MS21061L3K	NUTPLATE
42	MS27039-0810	SCREW
42	NAS1149DN832J	WASHER

(ADDED)

(WAS)

QTY -011	PART NUMBER	DESCRIPTION
X	D206-817-011	SCREW IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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4.0 WEIGHT AND BALANCE

The weight and balance for the D206-817-011 kit is as follows. These are net weights and include the parts removed.

Installation	Weight	LONGITUDINAL	
		Arm	Moment
D206-817-011	2.8 lb	40 in	112 in-lb
Screw-In Windshield Modification Kit	1.3 kg	1.0 m	1.3 m-kg

5.0 PARTS LIST

Qty -011	Part Number	Description
X	D206-817-011	SCREW-IN WINDSHIELD MODIFICATION KIT (MODIFIES BOTH LH & RH WINDSHIELDS)
1	D4541-3	BRACKET, LH
1	D4541-4	BRACKET, RH
1	D4541-5	BRACKET, LH
1	D4541-6	BRACKET, RH
1	D4541-7	BRACKET, LH
1	D4541-8	BRACKET, RH
2	D4542-3	RETAINER, INNER
2	D4542-5	RETAINER, INNER
2	D4542-7	RETAINER, INNER
1	D4543-1	RETAINER, LH OUTER (LOWER)
1	D4543-2	RETAINER, RH OUTER (LOWER)
1	D4543-3	RETAINER, LH OUTER (SIDE)
1	D4543-4	RETAINER, RH OUTER (SIDE)
1	D4543-5	RETAINER, LH OUTER (SIDE)
1	D4543-6	RETAINER, RH OUTER (SIDE)
1	D4544-1	RETAINER, CENTER
1	D4545-041	RETAINER, LH INNER (LOWER)
1	D4545-042	RETAINER, RH INNER (LOWER)
1	D4594-1	PLATE
1	D4595-150-25	SEALANT TAPE (25' LONG)
95	AN525-10R7	SCREW
112	MS20426AD3-4	RIVET
23	MS21059L08	NUTPLATE
56	MS21059L3K	NUTPLATE
10	MS21061L08	NUTPLATE
1	MS21075L08	NUTPLATE
22	MS27039-0810	SCREW
22	NAS1149DN832J	WASHER (OR AN960JD8)